



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.9710

Job Sheet 206659



REPRINT

Part No: 646.9710

Job Qty: 12 pcs

Part Name: Body



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/5/20

Job Tracking No:

Due Date: 4/8/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 646.9700 REV.H IPP REV:A NEW ISSUE 12/10/04 JFS VERIFY BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	HAAS 4 Axis	12 pcs	4/8/20		0.22	6.00	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
120	QC 2	12 pcs	4/8/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S263647



Part: 646.9710

Job No: 206659

Serial No/Batch: S263647

Revision: Rev H

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/26/20

See Mr

Plex 3/26/20 10:03 AM Dart.Guerin.Kimberley

				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
130	QC 8	12 pcs	4/8/20	0.00 0.00	QC 8 - 12
<i>See Attached</i>					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
140	Outsource - 4 - Anodize	12 pcs	4/7/20		ATG001-VC 10
150	Packaging 2-1 - Receive - B4B	12 pcs	4/7/20	0.00 0.00	Packaging 2 - 1 - B4B
<i>SEE ATTACHED</i>					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B

					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
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					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					Packaging 2 - 37 - B4B	
155	QC 6	12 pcs	4/7/20	0.00 0.00	QC 6 - 9	DAS 82 9-89
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	MAR 27 2020
					QC 6 - 81	DAS 87 9-89
160	Spray Paint - 2 - B4B	12 pcs	4/8/20	0.00 2.00	Spray Paint - 1 - B4B	MAR 29 2020
165	QC 14	12 pcs	4/8/20	0.00 0.00	QC 14 - 15	9-89
180	Packaging 3-1 - Stock - B4B	12 pcs	4/8/20	0.00 0.00	Packaging 3 - 1 - B4B	DAS 82 9-89
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	OK 012 9-89
					Packaging 3 - 4 - B4B	MAR 30 2020
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	DAS 21 9-89
					Packaging 3 - 37 - B4B	MAR 31 2020
190	QC 21 - SA	12 pcs	4/8/20	0.00 0.00	QC 21 - SA - 21	OK 012

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QC 21 - SA - 70

QC 21 - SA - 53

Part Op 110 - (HAAS CNC Vertical Machine), 1-Machine per folio FB130
 Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Outsource process-Anodize per QSI017 4.1.10.1), Issue P/O to: 46107 Hard Black Anodize Color Black and Prime as per Dwg 646.9700
 150 - (Receive & Inspect for Damage & Mat'l Certs)
 155 - (QC6- All purchased or subcontracted products) *MPP172 → cable cutter primer*
 160 - (Spray Paint / NDT Room)-PRIME CARDINAL 7760-4702 LOW-VOC EPOXY PRIMER (LIGHT GRAY) ; 236137
 165 - (QC14- Inspect Spray Paint)
 180 - (Identify as per dwg & Stock Location: _____), ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.000X5.000	7075-T6 Sheet1" Thick Plate X 5" Wide	7.4520 ft (.621 ea)	110-HAAS 4 Axis	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-HAAS 4 Axis	M7075T6S1.000X5.000	7	37	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Body	0.130Inches ± 0.010	0.140 0.120		
2	Body	45.0Angle ± 0.5	45.5 44.5		
3	Body	1.500Inches ± 0.005	1.505 1.495		
4	Body	0.352Inches + 0.005 - 0.000	0.357 0.352		
5	Body	0.100Inches ± 0.010	0.110 0.090		
6	Body	45.0Angle ± 0.5	45.5 44.5		
7	Body	0.875Inches ± 0.005	0.880 0.870		
8	Body	0.700Inches ± 0.005	0.705 0.695		
9	Body	5.500Inches ± 0.005	5.505 5.495		
10	Body	0.660Inches ± 0.005	0.665 0.655		
11	Body	0.660Inches ± 0.005	0.665 0.655		
12	Body	0.278Inches ± 0.002	0.280 0.276		
13	Body	0.339Inches ± 0.002	0.341 0.337		
14	Body	0.352Inches ± 0.002	0.354 0.350		
15	Body	0.372Inches ± 0.002	0.374 0.370		
16	Body	1.067Inches ± 0.002	1.069 1.065		
17	Body	2.608Inches ± 0.002	2.610 2.606		
18	Body	2.750Inches ± 0.002	2.752 2.748		
19	Body	2.892Inches ± 0.002	2.894 2.890		

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20	Body	3.348Inches ± 0.002	3.350 3.346
21	Body	3.597Inches ± 0.002	3.599 3.595
22	Body	3.847Inches ± 0.002	3.849 3.845
23	Body	0.351Inches ± 0.002	0.353 0.349
24	Body	0.544Inches ± 0.002	0.546 0.542
25	Body	2.195Inches ± 0.002	2.197 2.193
26	Body	2.304Inches ± 0.002	2.306 2.302
27	Body	2.451Inches ± 0.002	2.453 2.449
28	Body	2.639Inches ± 0.002	2.641 2.637
29	Body	3.395Inches ± 0.002	3.397 3.393
30	Body	3.495Inches ± 0.002	3.497 3.493
31	Body	4.551Inches ± 0.002	4.553 4.549
32	Body	4.595Inches ± 0.002	4.597 4.593
33	Body	4.687Inches ± 0.002	4.689 4.685
34	Body	4.734Inches ± 0.002	4.736 4.732
35	Body	6.651Inches ± 0.002	6.653 6.649
36	Body	0.201Inches + 0.005 - 0.001	0.206 0.200
37	Body	0.177Inches + 0.005 - 0.001	0.182 0.176
38	Body	7.026Inches ± 0.005	7.031 7.021
39	Body	4.245Inches ± 0.005	4.250 4.240

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646.9710

Job Sheet 206659



Part No: 646.9710

Job Qty: 12 pcs

Part Name: Body



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/5/20

Job Tracking No:

Due Date: 3/20/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 646.9700 REV.H IPP REV:A NEW ISSUE 12/10/04 JFS VERIFY BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	HAAS 4 Axis	12 pcs	3/20/20	0.22	6.00		HAAS - 1	JSD 20/5/13
							HAAS - 2	
							HAAS - 3	
							HAAS - 4	
120	QC 2	12 pcs	3/20/20	0.00	0.00		QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	



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Container No: S263647



Part: 646.9710

Job No: 206659

Serial No/Batch: S263647

Revision: Rev H

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/13/20

Plex 2/5/20 10:46 AM Dart.lajeunesse.marie

					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	JSD 2013/13
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 8 - 12	
					QC 8 - 14	20/03/15
130 QC 8	12 pcs	3/20/20	0.00 0.00		QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
140 Outsource - 4 - Anodize	12 pcs	3/20/20			ATG001-VC	10 JSD 2020-03-16
150 Packaging 2-1 - Receive - B4B	12 pcs	3/20/20	0.00 0.00		Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
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					Packaging 2 - 6 - B4B	
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					Packaging 2 - 36 - B4B	
					Packaging 2 - 37 - B4B	
155 QC 6	12 pcs	3/20/20	0.00 0.00		QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
180 Packaging 3-1 - Stock - B4B	12 pcs	3/20/20	0.00 0.00		Packaging 3 - 1 - B4B	
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					Packaging 3 - 3 - B4B	
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					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
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190 QC 21 - SA	12 pcs	3/20/20	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 110 - (HAAS CNC Vertical Machine), 1-Machine per folio FB130
 Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
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 150 - (Receive & Inspect for Damage & Mat'l Certs)
 155 - (QC6- All purchased or subcontracted products)
 180 - (Identify as per dwg & Stock Location: _____), ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.000X5.000	7075-T6 Sheet1" Thick Plate X 5" Wide	7.4520 ft (.621 ea)	110-HAAS 4 Axis	5256977

cut blank at 7.425

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-HAAS 4 Axis	M7075T6S1.000X5.000	7	33	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Body	0.130Inches ± 0.010	0.140 0.120	.130	
2	Body	45.0Angle ± 0.5	45.5 44.5	45°	
3	Body	1.500Inches ± 0.005	1.505 1.495	1.502	
4	Body	0.352Inches + 0.005 - 0.000	0.357 0.352	0.3561	
5	Body	0.100Inches ± 0.010	0.110 0.090	.105	
6	Body	45.0Angle ± 0.5	45.5 44.5	45°	
7	Body	0.875Inches ± 0.005	0.880 0.870		
8	Body	0.700Inches ± 0.005	0.705 0.695		
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35	Body	6.651Inches ± 0.002	6.653 6.649
36	Body	0.201Inches + 0.005 - 0.001	0.206 0.200 0.202
37	Body	0.177Inches + 0.005 - 0.001	0.182 0.176 .177
38	Body	7.026Inches ± 0.005	7.031 7.021
39	Body	4.245Inches ± 0.005	4.250 4.240

Plex 2/5/20 10:46 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046107



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046107

PO Date: 3/16/20

Due Date: 3/30/20

Purchase Order

Revision:

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2020-03-26

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	205052	646.9713	646.9700 Rev H	Body Issue P/O to ATG Anodize, Color Black, Prime as per Dwg 646.9700	Firmed	-	3/30/20	20 pcs	0 pcs	20 pcs	\$16.08/pcs	\$321.60
2	207119	D4726-1	D4726 Rev B	Handle : Various STC's Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1)	Firmed X12	-	3/30/20	12 pcs	0 pcs	12 pcs	\$4.28/pcs	\$51.36
3	206659	646.9710	646.9700 Rev H	Body : Various STC's (Outsource process-Anodize per QSI017 4.1.10.1), Issue P/O to: Hard Black Anodize Color Black and Prime as per Dwg 646.9700	Firmed X12 ✓	-	3/30/20	12 pcs	0 pcs	12 pcs	\$9.08/pcs	\$108.96



Sherrin



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB046107



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

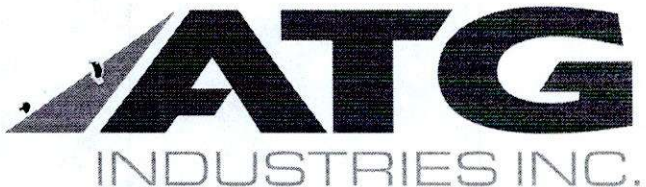
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/26/20 10:13 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919876

Date: 26-Mar-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
12 ea	Part: 646.9710 Body Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (5 - 4.5mils) Job: 27155 PO: POHB046107	Rev: H Line: 3	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>MAR 26 2020</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. RECEIVED MAR 26 2020 DART AEROSPACE LTD.			

Made in Canada.